

FIG. 1

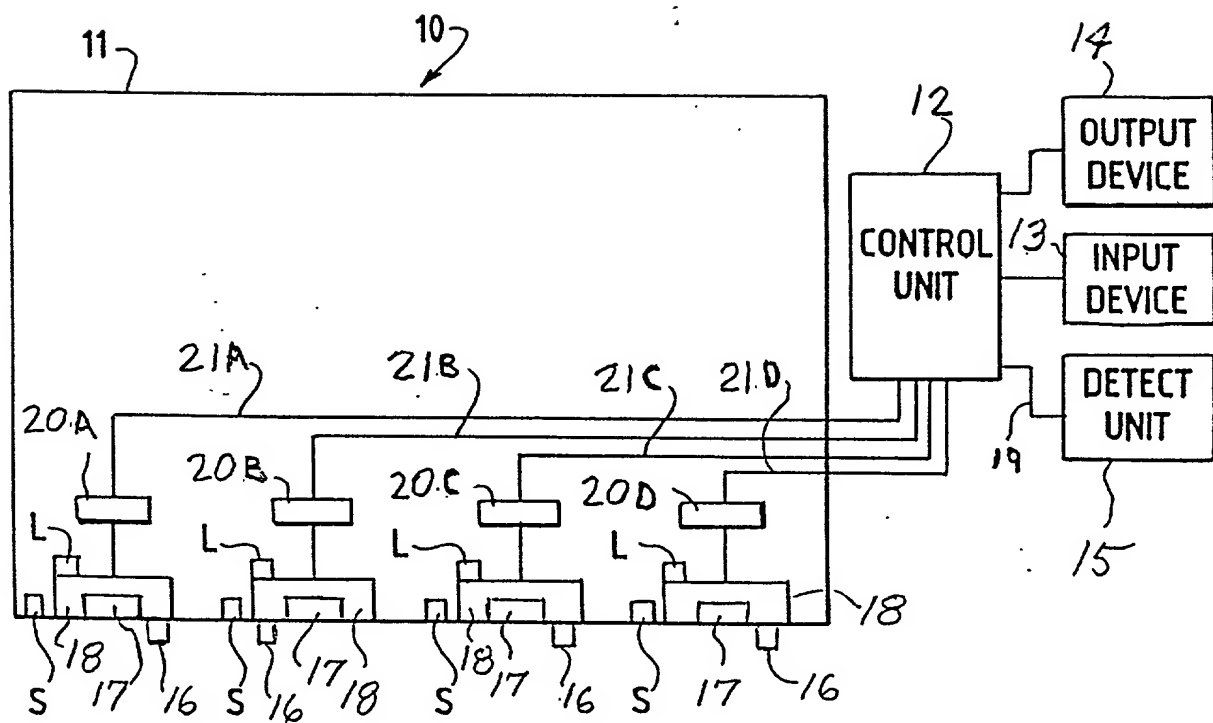


FIG. 2A

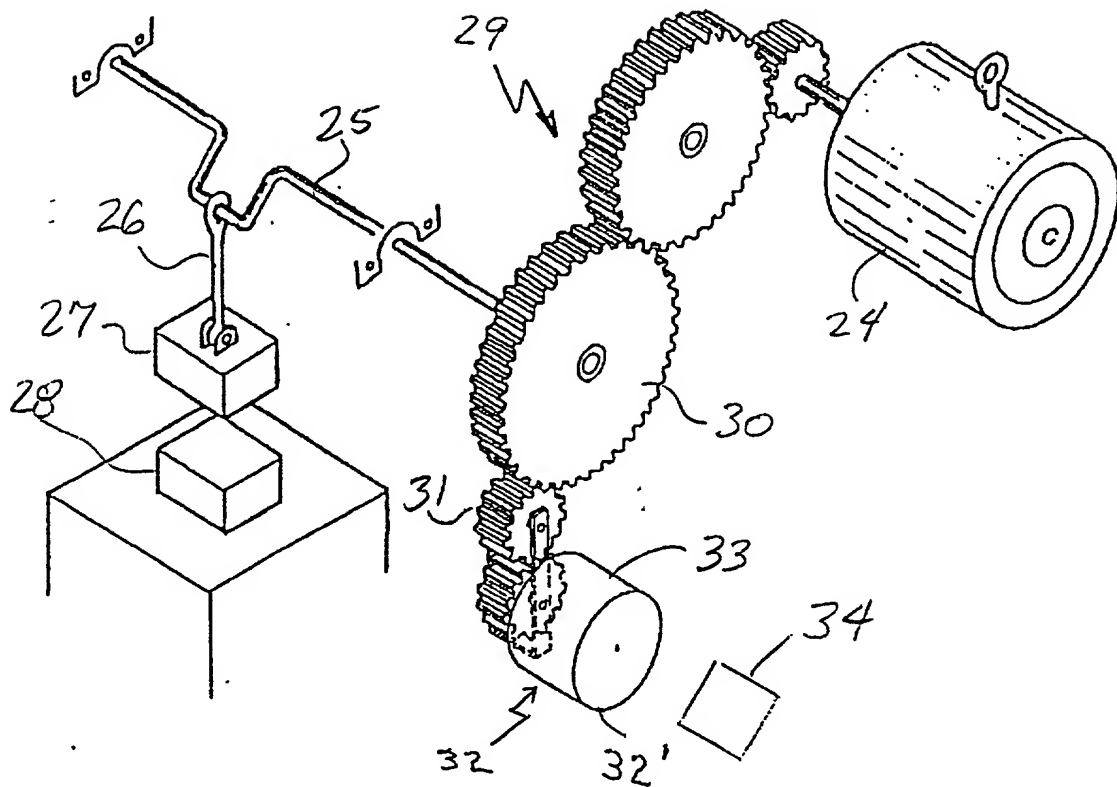


FIG. 2B

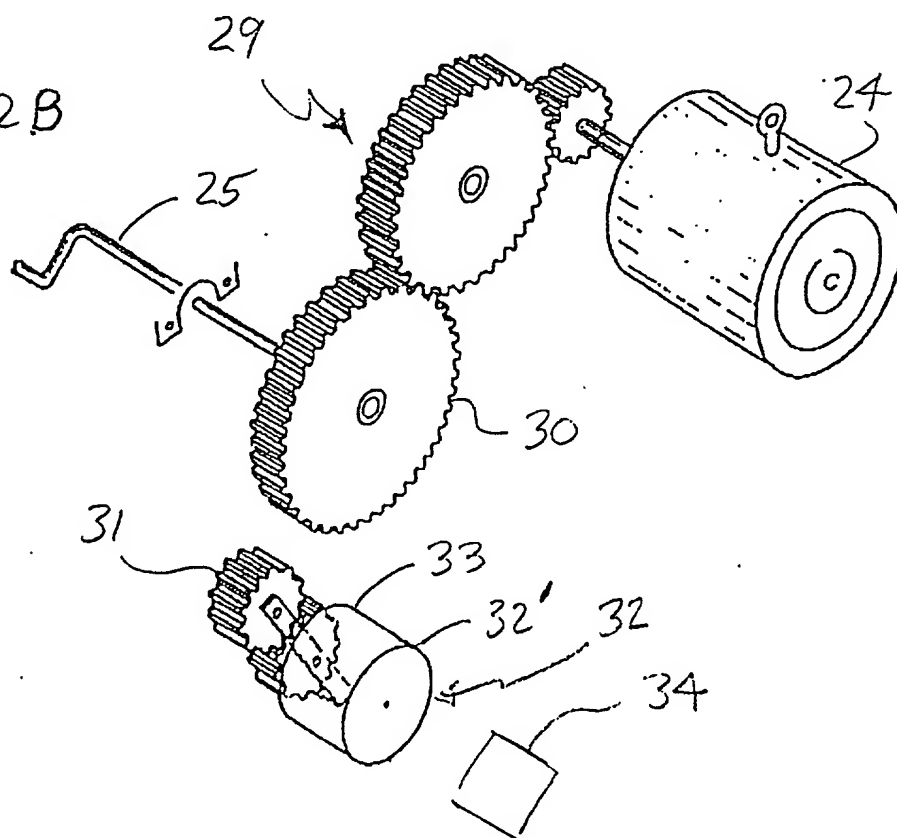


FIG. 3

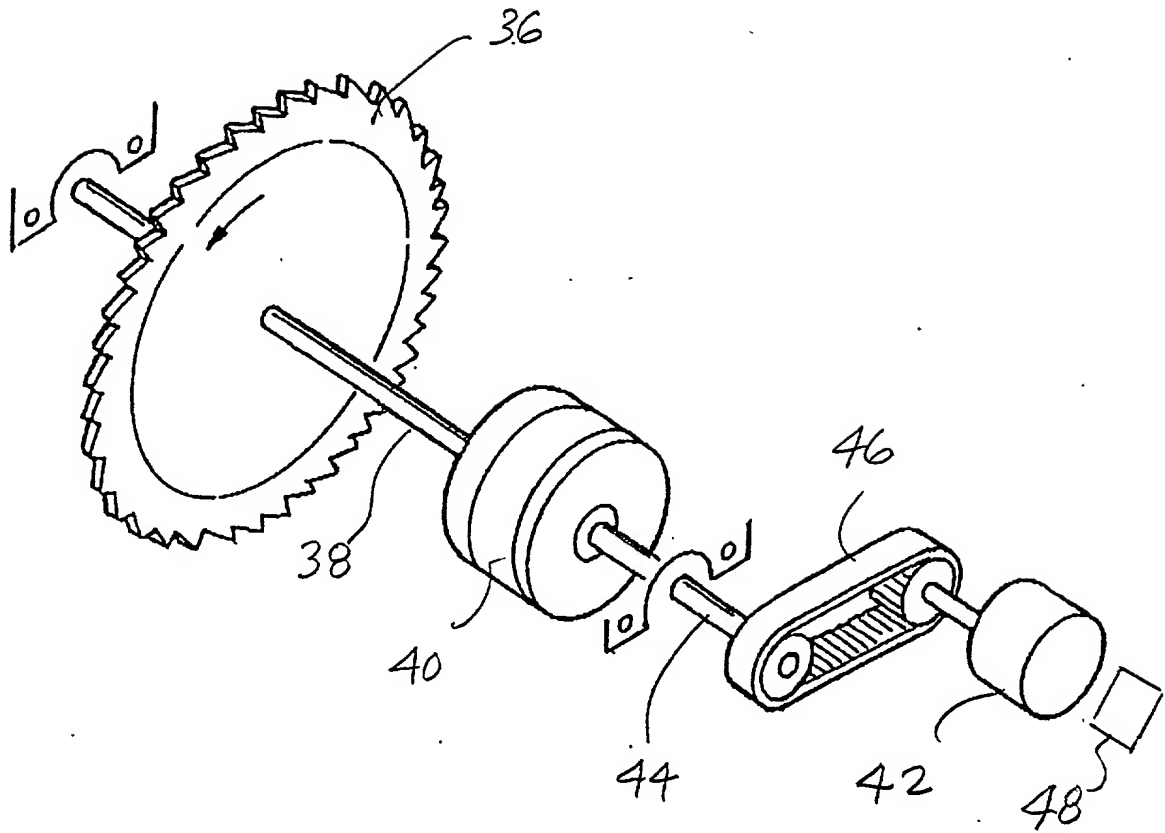


FIG. 4 ZERO SPEED INDICATOR TEST SUBROUTINE  
IN SITU TESTING WHILE THE MACHINE IS RUNNING

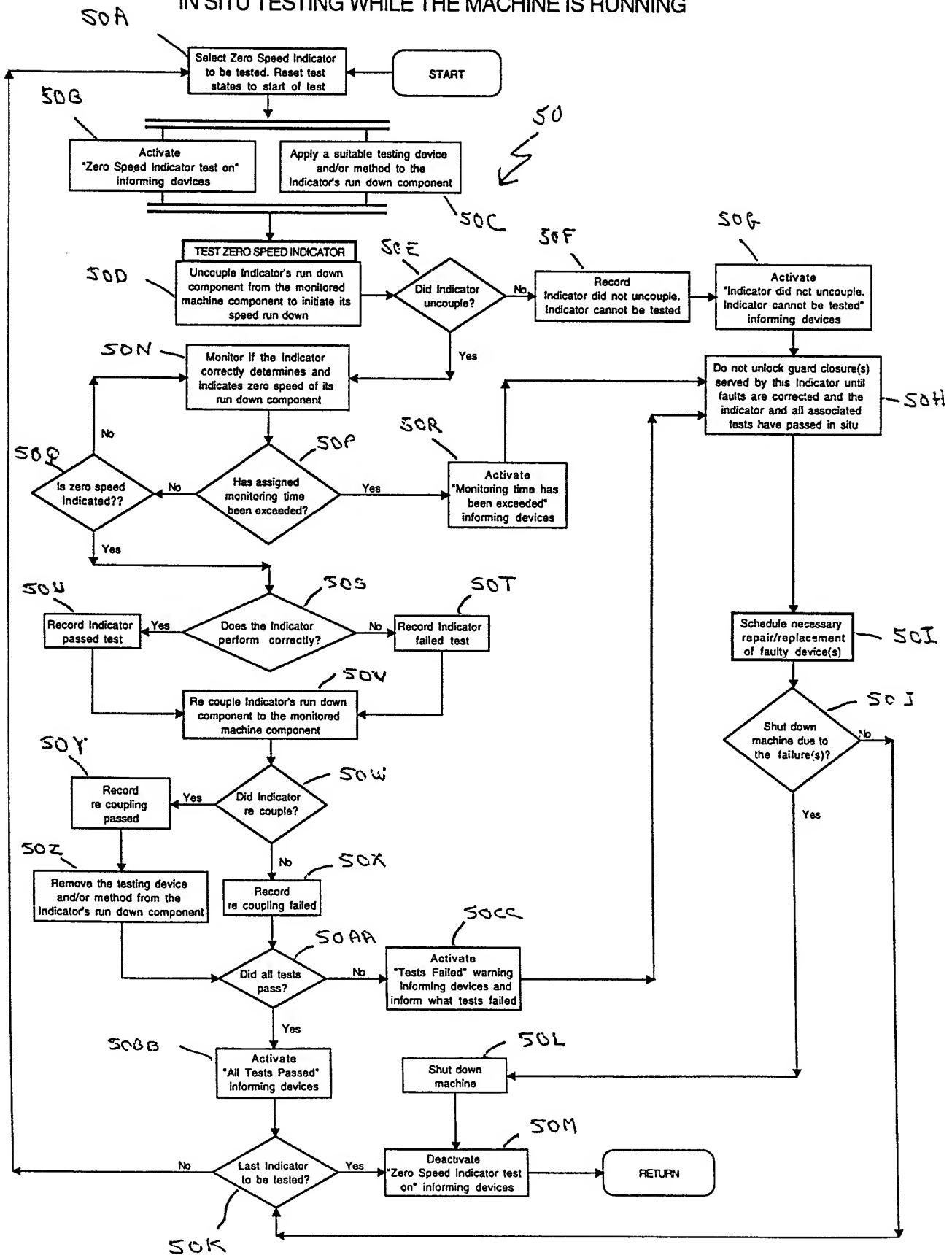


FIG. 5

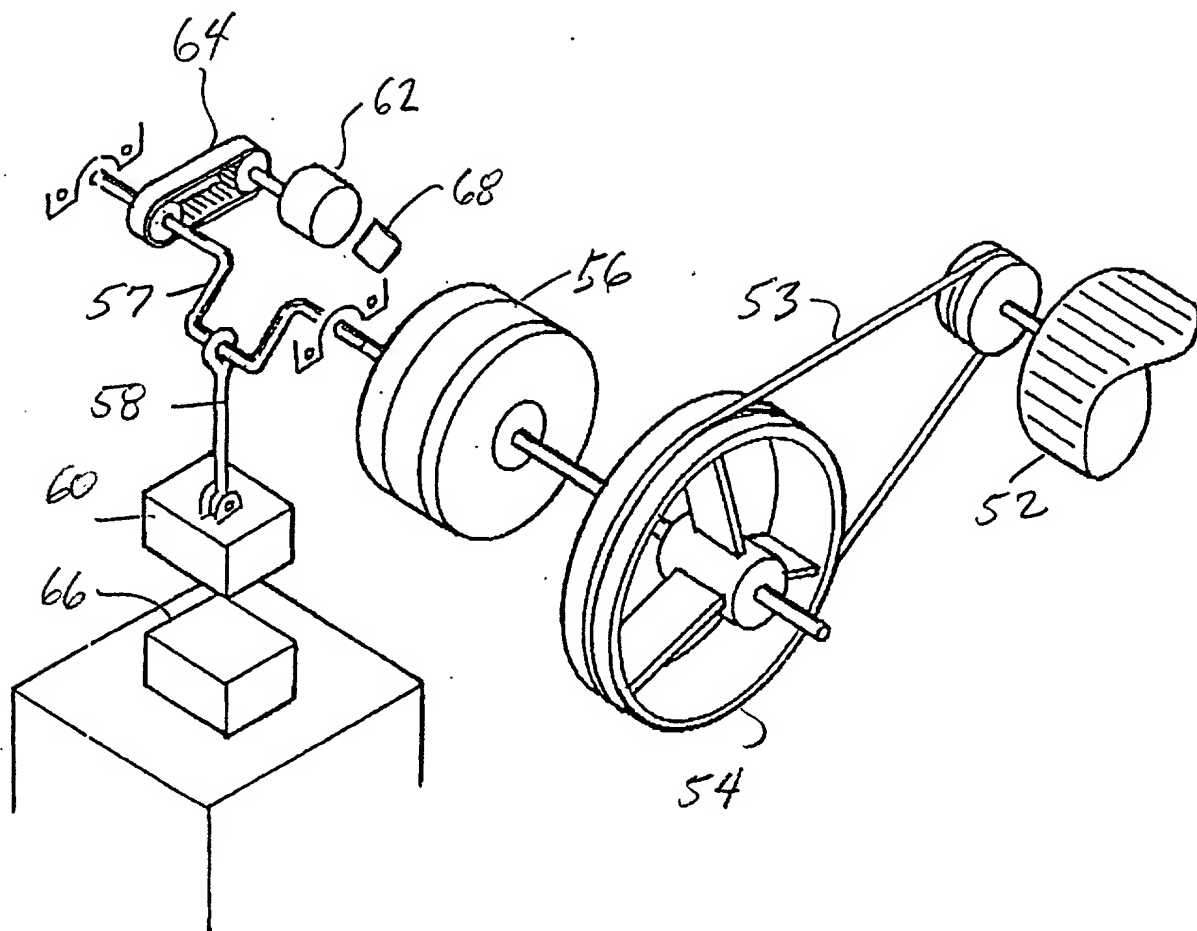
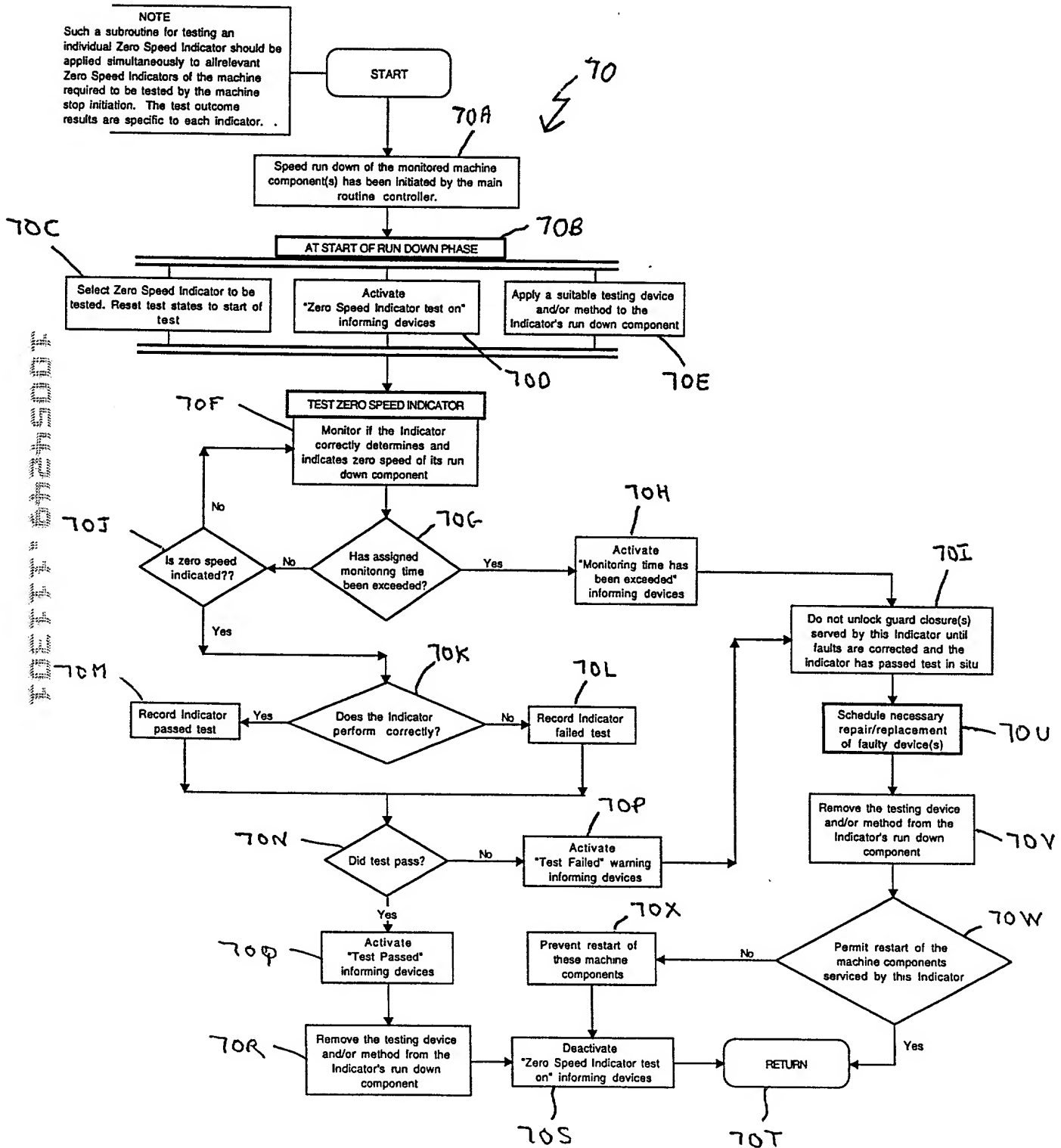


FIG. 6 ZERO SPEED INDICATOR TEST SUBROUTINE  
IN SITU TESTING DURING THE SPEED RUN DOWN PHASES  
CAUSED BY MACHINE STOP INITIATIONS



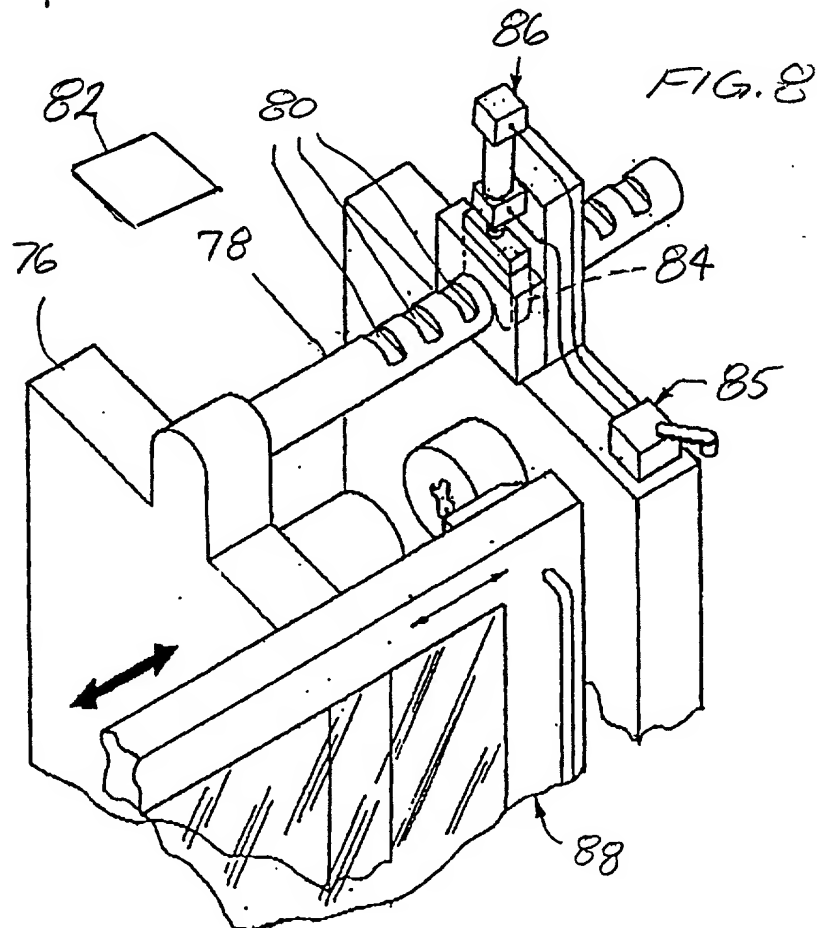
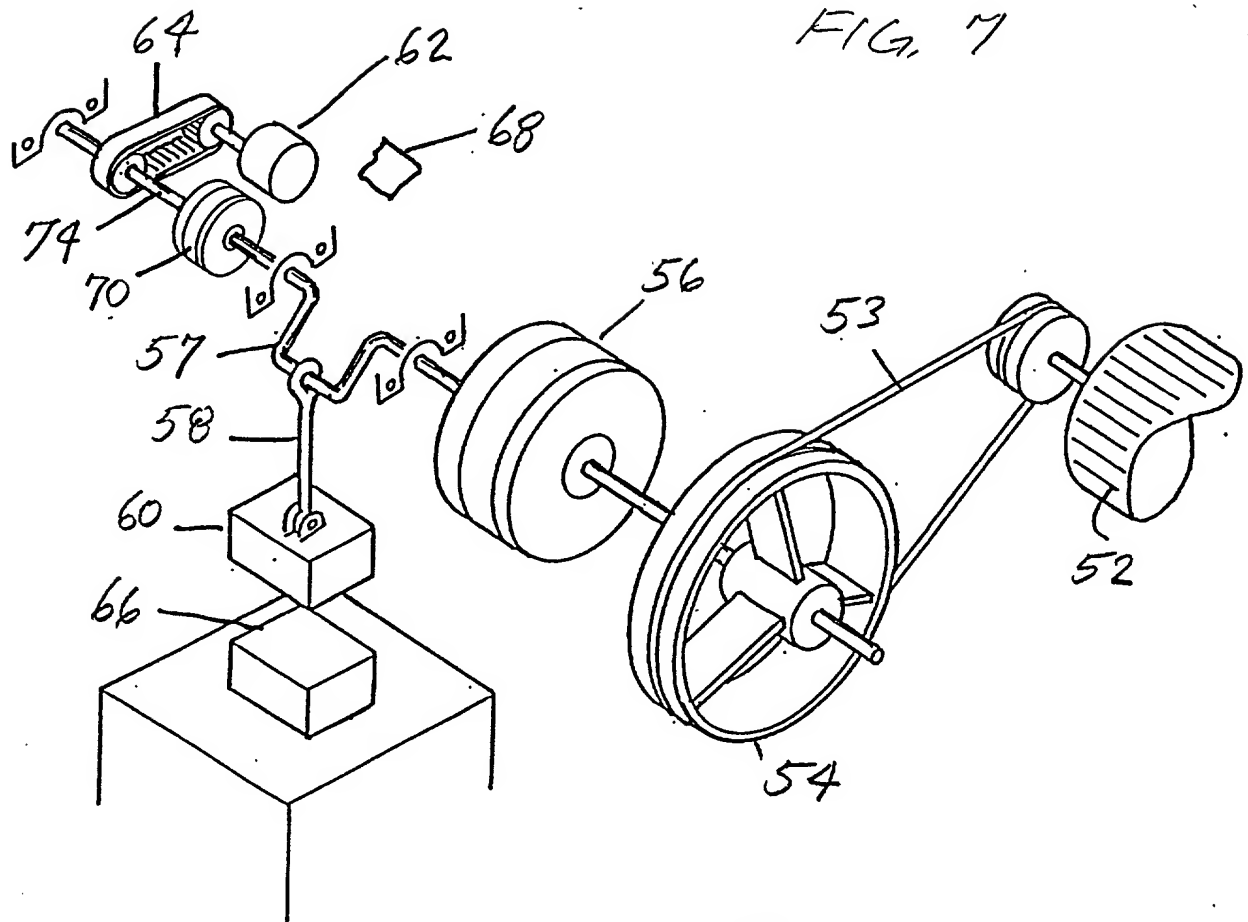
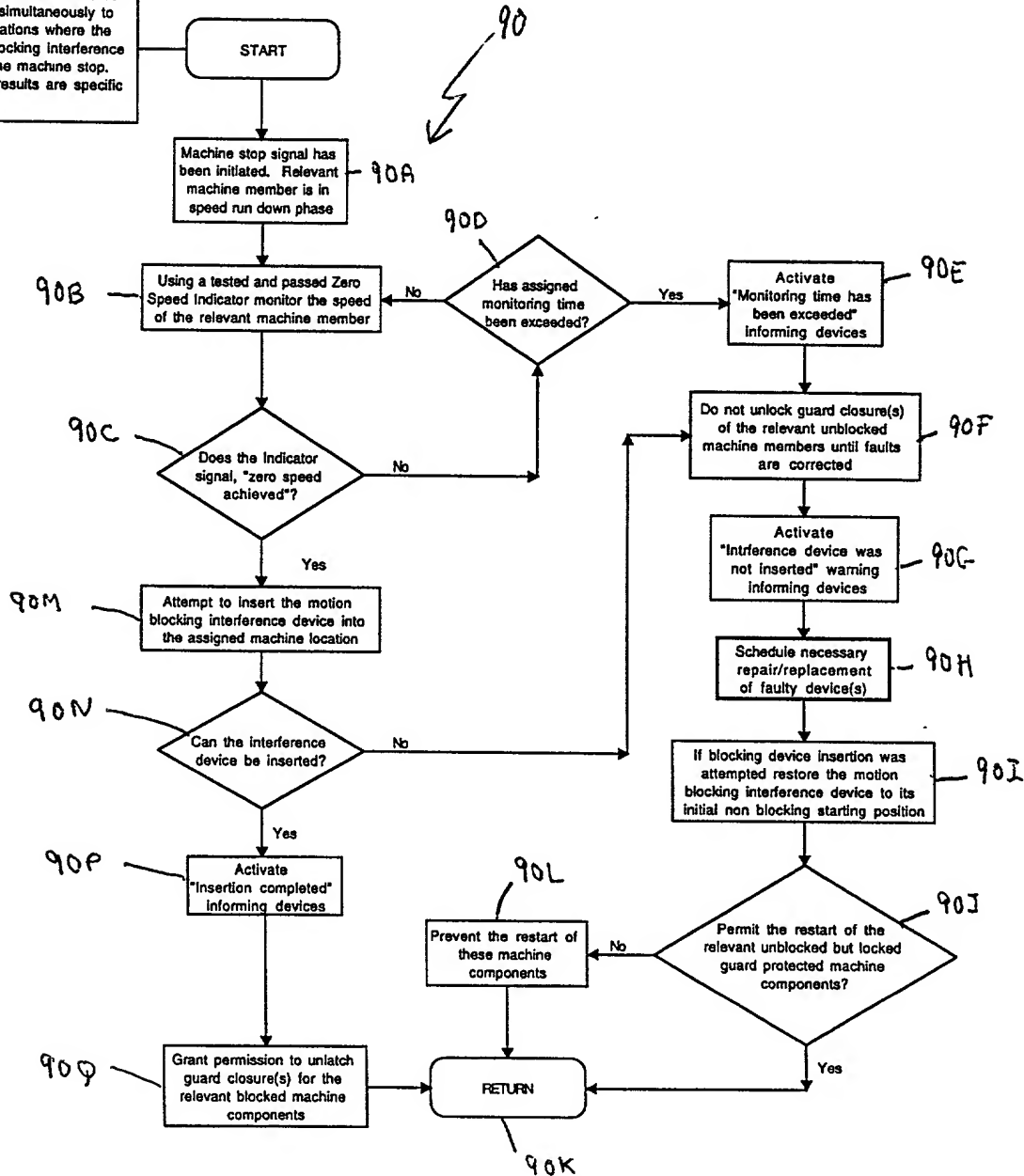


FIG. 9 SUBROUTINE FOR INSERTION OF A MOTION INTERFERENCE DEVICE AT SPEED RUN DOWN COMPLETION CAUSED BY MACHINE STOP INITIATIONS

NOTE

Such single location subroutines are to be applied individually but simultaneously to all relevant machine locations where the insertion of a motion blocking interference device is called for by the machine stop. The insertion outcome results are specific to each location.





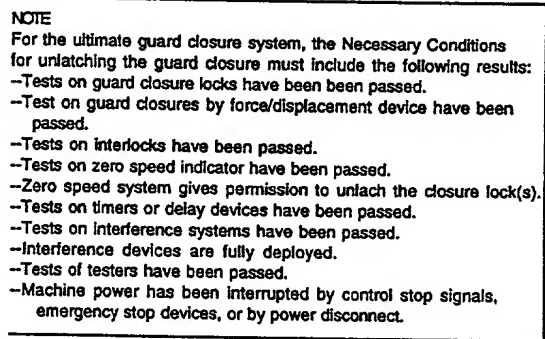
[illegible]

FIG. 11A EXAMPLE MAIN ROUTINE  
FOR TESTING SAFEGUARDING DEVICES AND  
SYSTEMS FOR GUARD CLOSURES

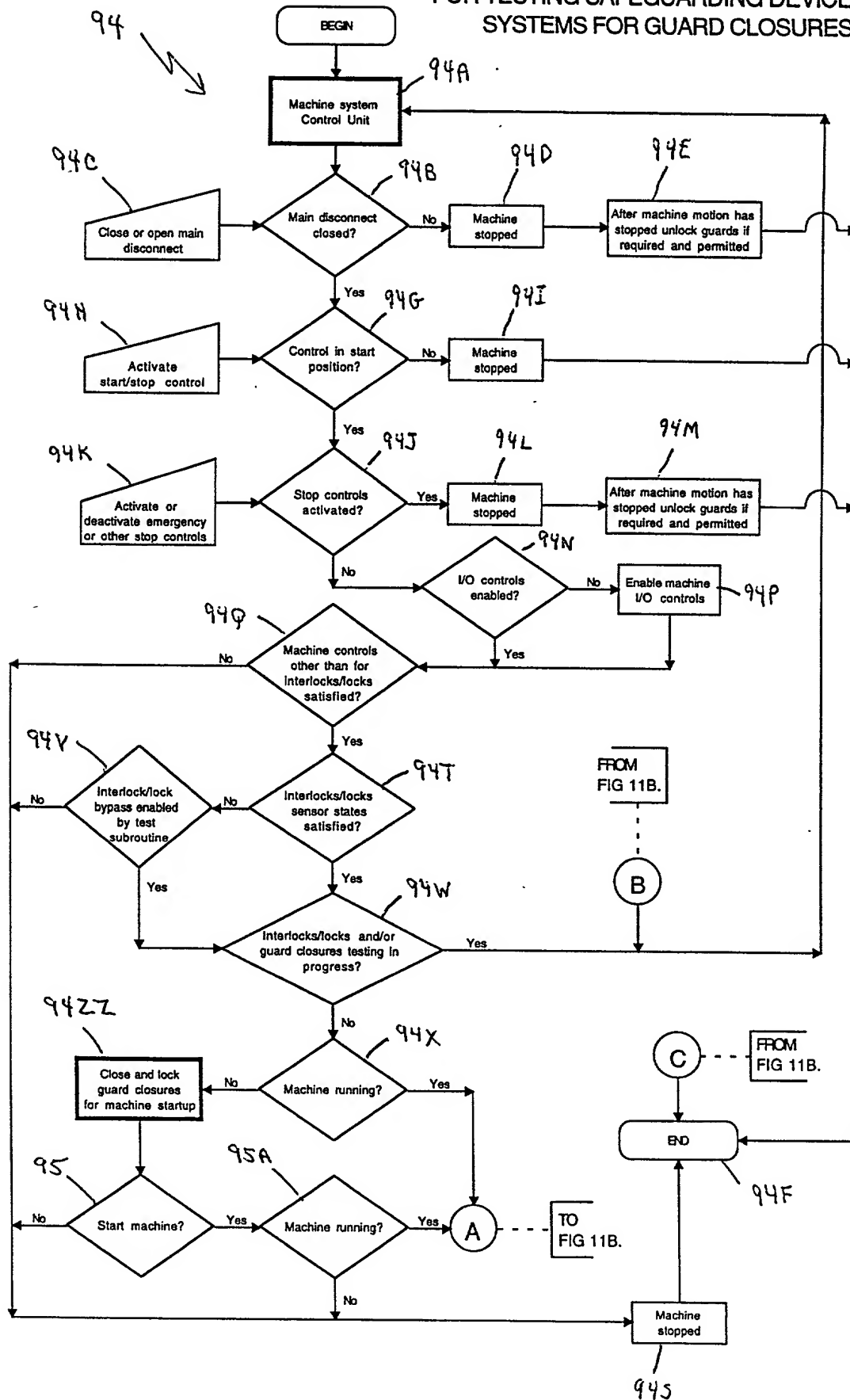


FIG. 11B EXAMPLE MAIN ROUTINE  
FOR TESTING SAFEGUARDING DEVICES AND  
SYSTEMS FOR GUARD CLOSURES

